

Date: Monday, 07/04/2008 2:30:27 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 38451	
Estimate Number : 10438	
P.O. Number :	Part Number : D32991
This Issue : 07/04/2008 S.O. No. :	Drawing Number : D3299 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35138	Material :
Written By :	Due Date : 30/04/2008 Qty: 8 Um: Each
Checked & Approved By : <u>J.D. 08.4.06</u>	
Comment : Est Rev:A 04.10.04 New issue KJ/JLM	
Est Rev:B 07-06-11 Removed Manual Machining & Hex Bar	
JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25"
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Comment: Qty.: 0.2013 f(s)/Unit Total: 1.6103 f(s)
 6061T6 BAR 1.250" X1.250"
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.250"X1.250"

Batch: M104554

J.F. 08/04/21 (8)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL
 Cut blank: 2.200" long
 Turn as per Folio FA451 and Dwg D3299

J.F. 08/04/21 (8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/04/21 (8)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS
 Machine as per Folio FA451 and Dwg D3299
 CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299
 Deburr

J.F. 08/05/16 (8)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/05/16 (8)

Date: Monday, 07/04/2008 2:30:27 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 38451

Part Number: D32991

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 08/05/17 (8)

7.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 6520
Anodize as per Dwg D3299
Possible Supplier: TNM Paint
Material release note is required

C208106106 (8)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Recieve & Inspect for Transit Damage
Ensure Material Release Note is attached

P8/6/15 (8)

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S08/06/20 (8)

10.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 82

8/6/20

8X
SD

11.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/06/23

Job Completion



MF 08-06-23

DART AEROSPACE LTD		Work Order: 38451
Description: Fitting		Part Number: D3299-1
Inspection Dwg: D3299	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.253"	✓			
0.476	+0.000/-0.005	.473"	✓			
0.550	+/-0.010	.551"	✓			
1.00	+/-0.030	1.003"	✓			
2.10	+/-0.030	2.100"	✓			
0.773	+/-0.010	.779	✓			
0.10	+/-0.030	.100"	✓			
0.20	+/-0.030	.200"	✓			
0.550	+/-0.010	.546"	✓			
MOW Max = 0.573 Min = 0.565	Max = 0.573	.573"	✓			
Ø0.302	+0.005/-0.000	Ø.306"	✓			
Ø0.688	+0.005/-0.000	Ø.690	✓			
Ø0.580	+0.005/-0.000	Ø.580	✓			
53°	+/-0.5°	53°	✓			
1.09	+/-0.030	1.100	✓			

Measured by: J.F./amk	Audited by: RP	Prototype Approval:	N/A
Date: 08/04/21	Date: 08/04/21	Date:	N/A

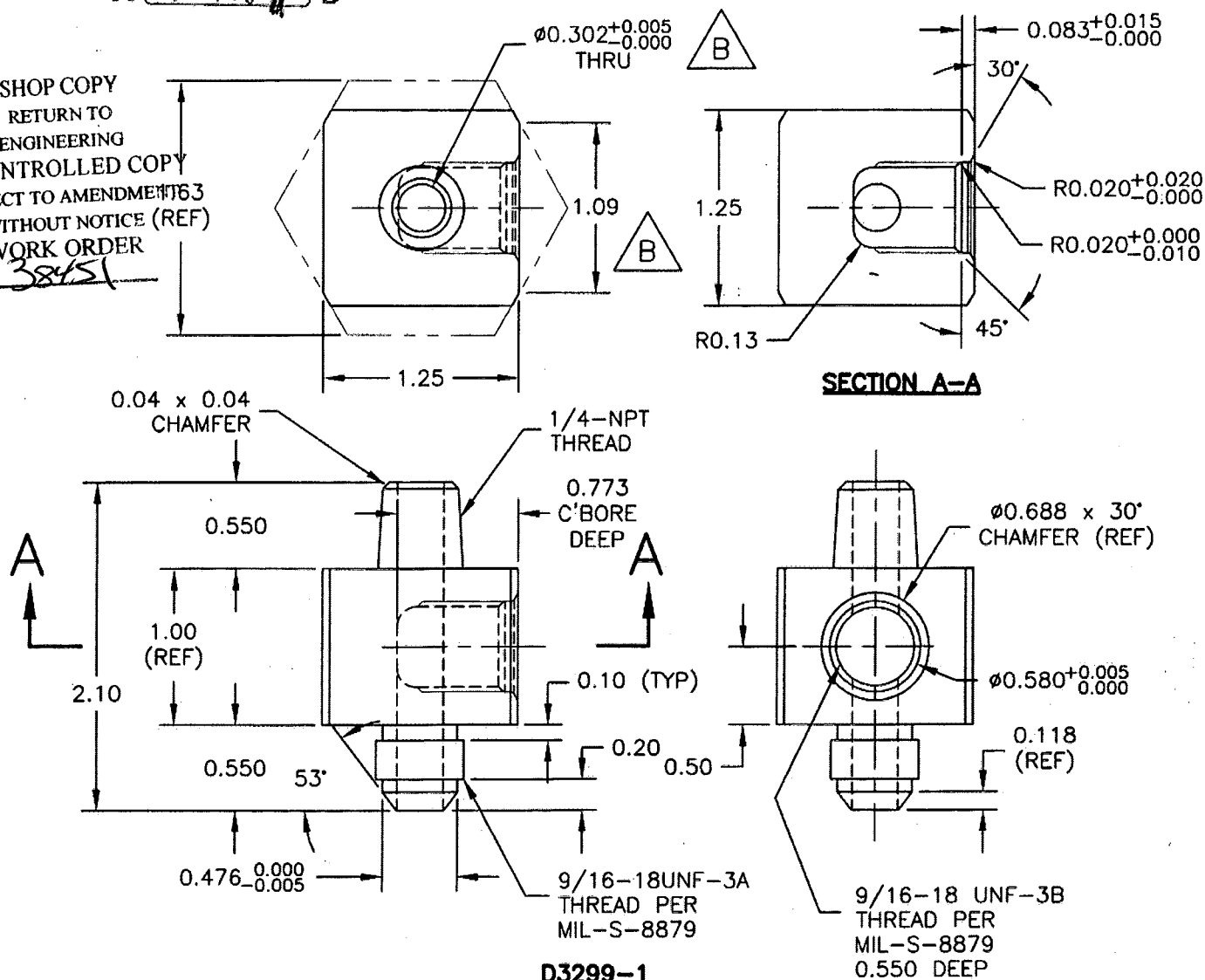
Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED
05.04.28

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WITHOUT NOTICE (REF)
WORK ORDER
NO 38451



D3299-1

D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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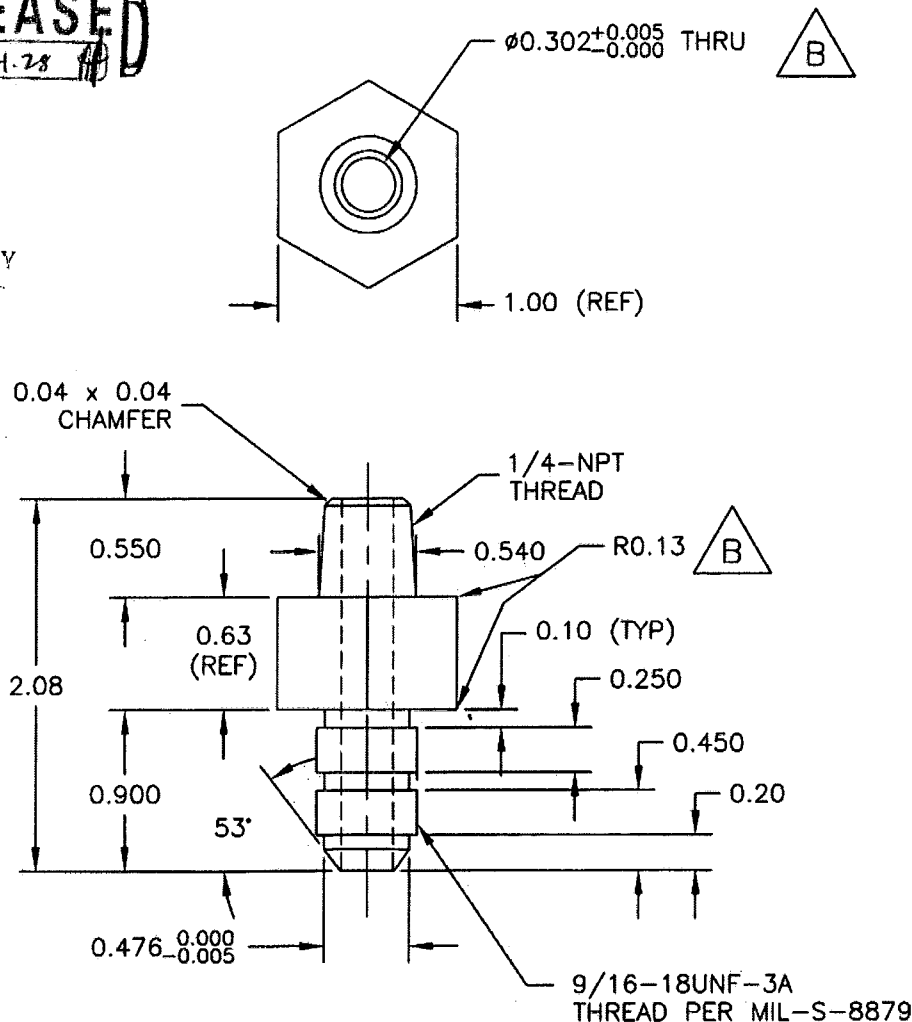
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DATE 05.04.28		TITLE FITTING	SCALE 1:1

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NO. 38451



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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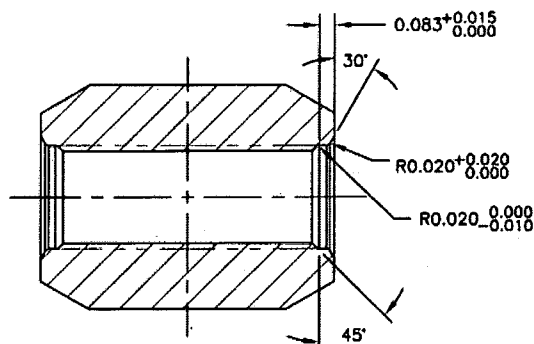
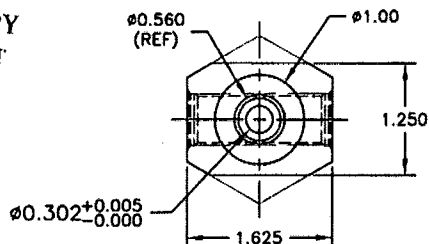
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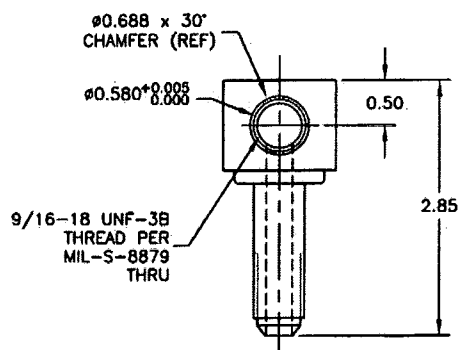
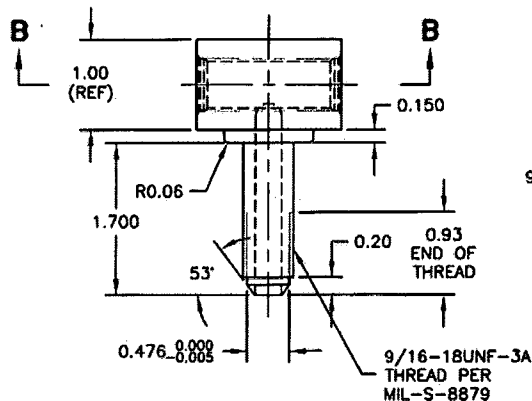
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CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

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NO 38451



SECTION B-B
SCALE 1:1



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/B OR QQ-A-225/B) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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1 INMI

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

65597

11-Jun-2008

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE

NO. DE COMMANDE:

PURCHASE ORDER/ 6520



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	412-200-002-006 B39	DWG: D41232-200-002 REV. A
4	8	8	D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62	D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62	D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
				BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: Directeur de la Qualité / Q.A. Manager 